

Work Order ID 83433

83433

Page 1

April-18-12 8:15:41 AM

Item ID: D3536-21

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Gasket

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Debur if necessary

B12-4-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-20

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizler/27

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *FP*

0.00

130

Packaging

Memo

0.00

Packaging

12x

SP
12-04-27

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/30

12-04-27

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Picklist Print

April-18-12 8:15:44 AM

Page 1

Work Order ID: 83433

83433

Parent Item: D3536-21

D3536-21

Parent Item Name: Gasket

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	599.7520	0.8503	11.33733			

MNEO60S 063

NEOPRENE SHEET 0.063

**

IB12-4-26

Location

Loc Qty

Loc Code

MAT052

599.752

120948

599.752

120948

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83433
Description: Gasket		Part Number:	D3536-21
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.70	+/-0.030	32.70	✓		T Bol	
27.25	+/-0.030	27.25	✓		T	
21.80	+/-0.030	21.80	✓		T	
16.35	+/-0.030	16.35	✓		T	
10.90	+/-0.030	10.90	✓		T	
5.45	+/-0.030	5.45	✓		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
2.00	+/-0.030	2.00	✓		V Bol	
0.90	+/-0.030	.900	✓		V	
0.30	+/-0.030	.301	✓		V	
0.30	+/-0.030	.303	✓		V	
1.89	+/-0.030	1.888	✓		V	
Ø0.19	+0.004/-0.001	.193	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 12-4-24	Date: 12/4/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	DD

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

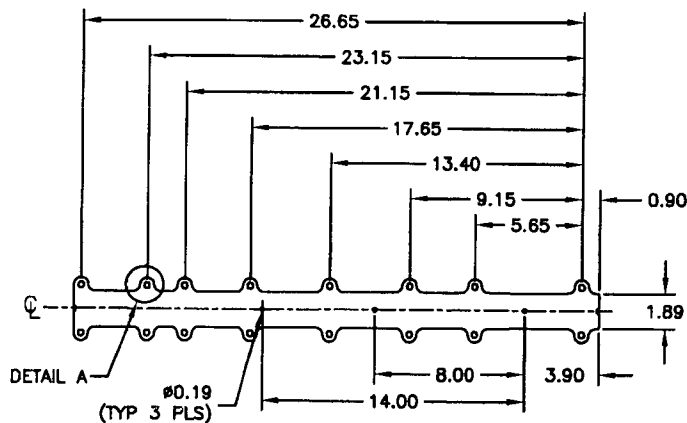
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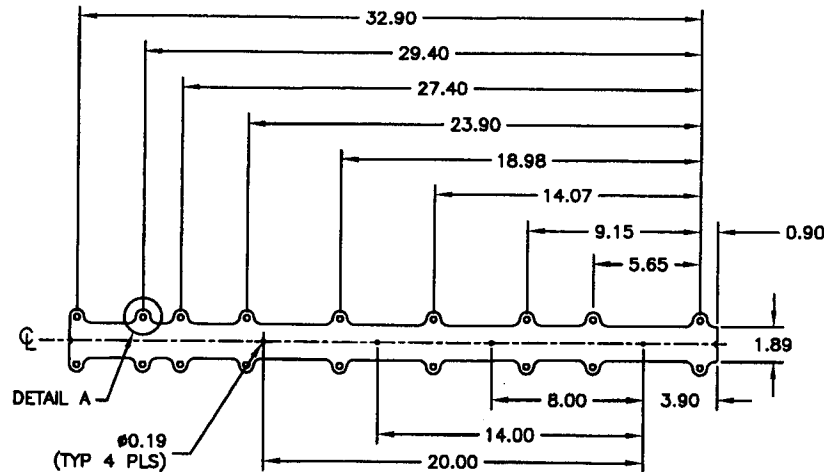
DART

RELEASED
09 02.12.18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83433 MLJ
12/04/18



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10

W/O:		WORK ORDER CHANGES					
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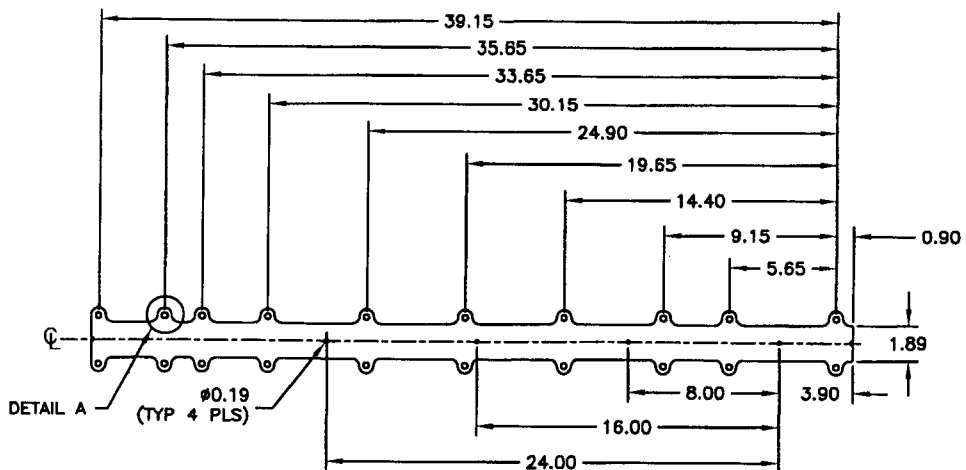
NOTE: Date & initial all entries

DART

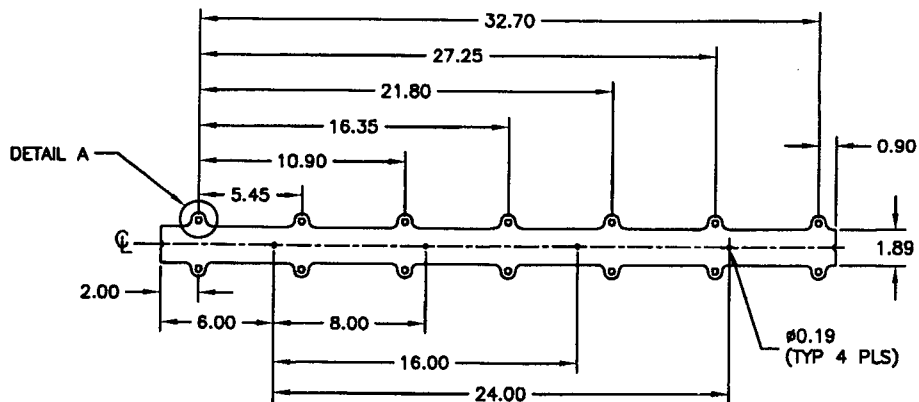
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CHECKED	AH	APPROVED	AH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
				SCALE 1:10

83433

RELEASED
07.02.12



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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Dart Aerospace Ltd

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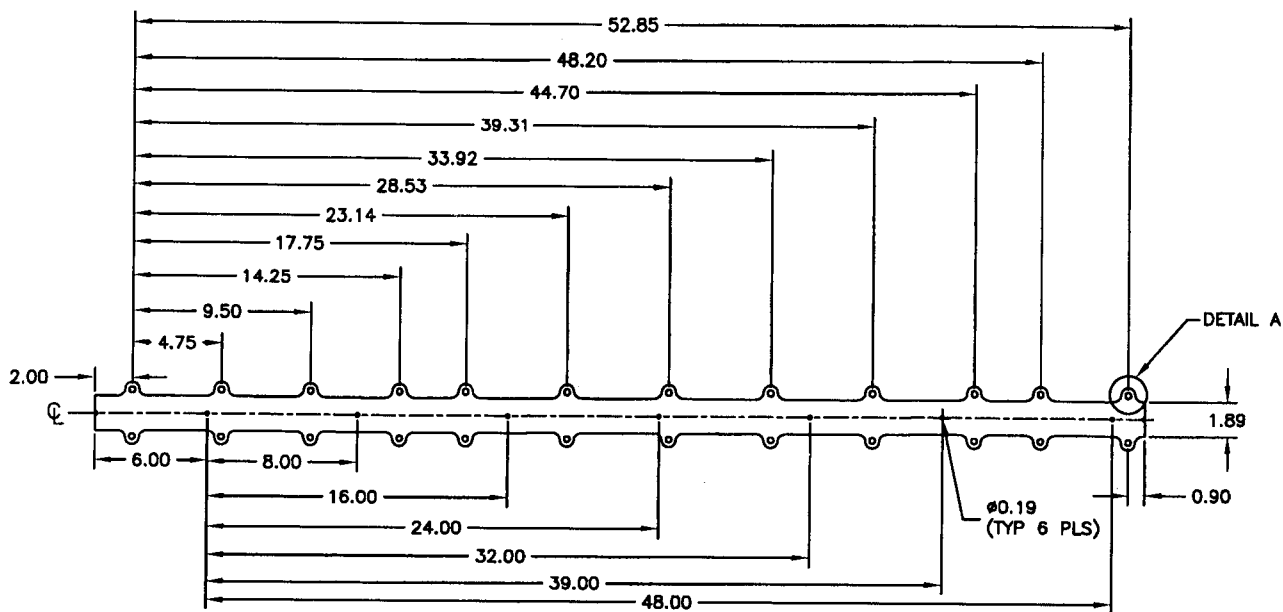
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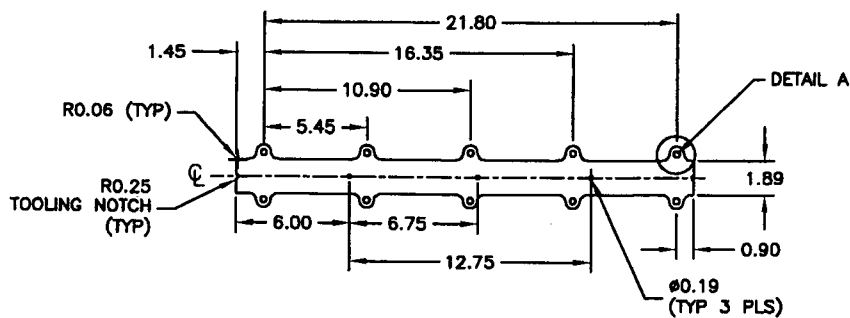
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CHECKED	PH	APPROVED	PH	
DATE	06.10.25	TITLE	D3536	
		GASKET		
		REV. A	SHEET 3 OF 6	

83433

070212
070212



D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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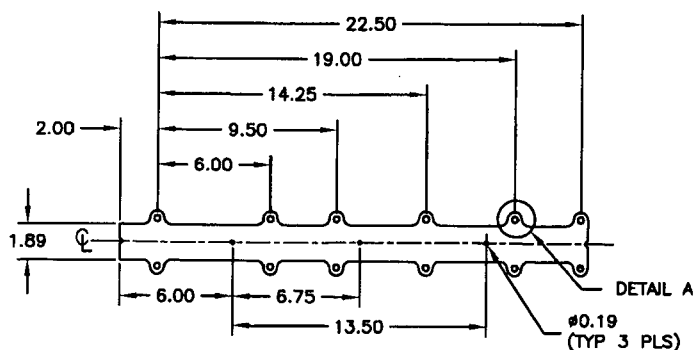
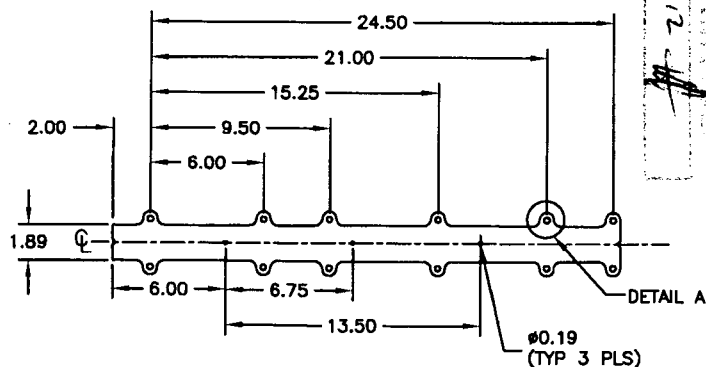
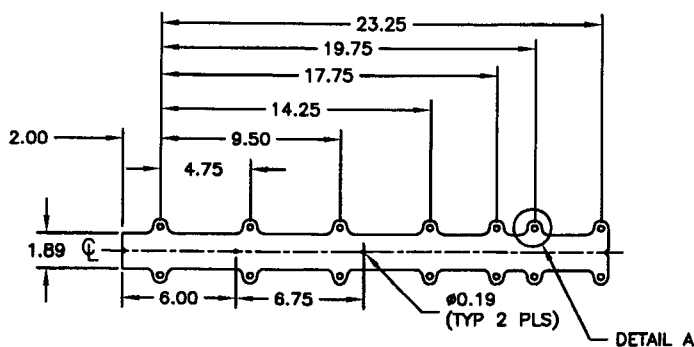
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DART

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CHECKED PH	APPROVED PH	PORT HADLOCK, WA
DATE 06.10.25	TITLE GASKET	DRAWING NO. D3536
		REV. A
		SHEET 4 OF 6
		SCALE 1:10

**D3536-31 GASKET****D3536-33 GASKET****D3536-35 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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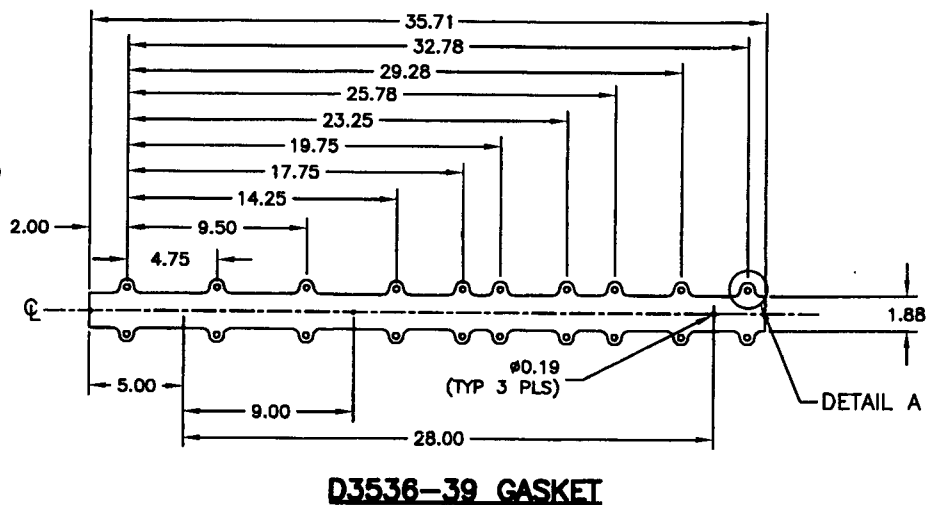
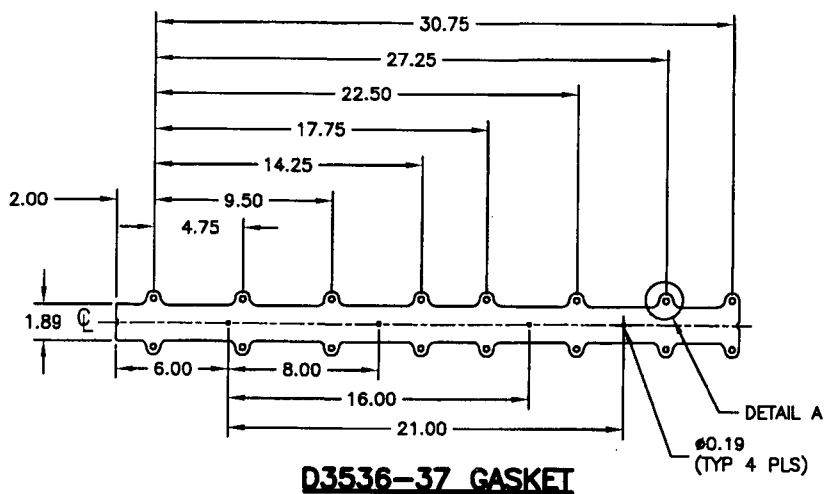
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CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6	SCALE 1:10

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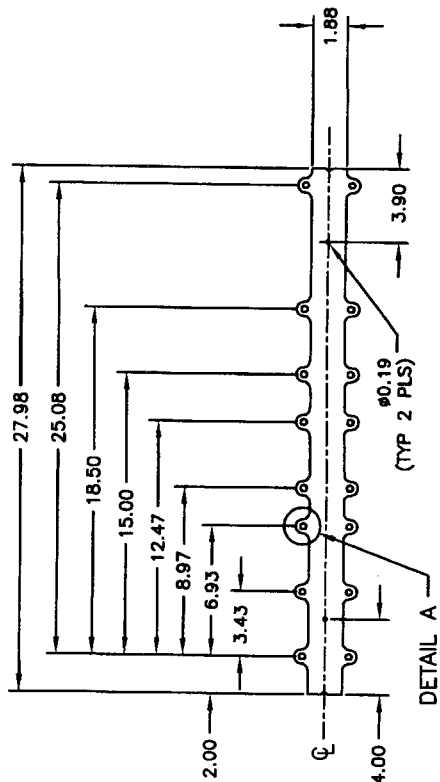
NOTE: Date & initial all entries

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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10

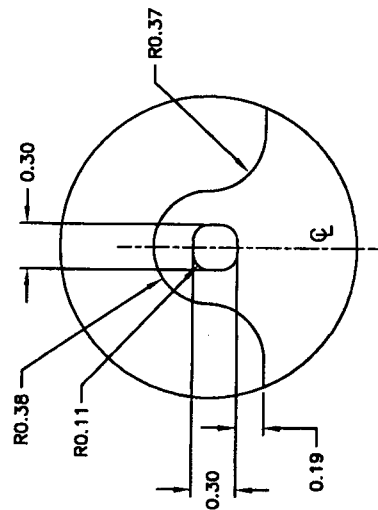
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DETAIL A

D3536-41 GASKET

DETAIL A



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
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